

**TYPE**

A phenolic resin (baked, unmodified) with superior resistance to acids and solvents.

**INTENDED USE**

Tank lining for solvents, acids, hot water, food products and as a protective coating for ducts, machinery parts, filter press plates, rayon machine parts, fans, oil well tubular goods, etc. PLASITE 3066 meets the FDA requirements for 21 CFR, 175.300. FOR INDUSTRIAL USE ONLY!

**TEMPERATURE RESISTANCE**

Non-immersion basis is 400°F; 450°F for short periods.

**COLOR**

Ivory changing to medium tan after baking.

**COVERAGE**

94 ft<sup>2</sup>/gal. (2.3 sq.m/l @ 6 mils/0.15mm. For estimating purposes, 85 sq. ft/gal. (10% loss included).

**NUMBER OF COATS**

Immersion: 3 or more coats will produce the recommended dry film thickness of 5-7 mils/125-175 microns (approximately 1-1.5 mils/25-38 microns per coat). Non-Immersion: For specialized service (which is not subject to immersion conditions), the number of coats and dry film thickness may be decreased depending on severity of the service. Consult Carboline Technical Service Department for further information.

**THINNERS**

PLASITE Thinner #30 is recommended for thinning.

**Cleanup Thinner:** Thinner #71

**BAKING SCHEDULE**

Intermediate Coats: 20 to 30 minutes at 180-200°F/82-93°C metal temperature.

Final Bake: 1 1/2 hours at a minimum 375-400°F/191-204°C metal temperature.

For concentrated sulfuric acid service, a final bake at 400°F/204°C metal temperature is required.

**VOC CONTENT**

Coating as Supplied (Determined Theoretically)		Thinned 33% by Volume with PLASITE Thinner #30 (Determined Theoretically)		
Color	Lbs./Gal.	g/L	Lbs./Gal.	g/L
Ivory	4.4 ± 2%	527 ± 2%	5 ± 2%	599 ± 2%

**PHYSICAL SPECIFICATIONS**

**Abrasion Resistance:** 59.7 milligrams average loss per 1000 cycles

Taber CS-17 Wheel.....1000 gram weight

**Surface Hardness**

Konig Pendulum Hardness of 188 seconds (Glass Standard = 250 seconds)

(ASTM Method D4366-84)

**Pigments**.....Titanium dioxide and inert pigments.

**Solids**.....60% ± 2% by weight  
35% ± 2% by volume

**Shelf Life**.....6 months at 70°F.

**Viscosity**

For spray, adjust with PLASITE Thinner #30 16 to 20 seconds Ford Cup #4 at 70°F (viscosity approximated by adding 1 part PLASITE Thinner #30 to 3 parts coating).

**Note:** For dipping, start with same viscosity which may require some adjustment to conform with size and shape of object being coated.

**Thermal Shock**.....Unaffected 5 cycles minus  
70°F to plus 200°F

**Gloss**.....80°

**CHEMICAL RESISTANCE**

PLASITE 3066 is classified as a relatively thin film coating and should not be used for total and continuous immersion in certain chemicals which have extremely high corrosion rate to mild steel and other substrates.

Refer to PLASITE TD-2 Bulletin for complete test data. Contact Carboline Technical Service Department for further information.

Degree of final cure may be determined by comparing cured coating to predetermined color sample panels. A panel depicting final cure is available on request.

**Caution:** Overbaking between coats will result in loss of intercoat adhesion.

# PLASITE® 3066

## SURFACE PREPARATION

### Steel

#### High Temperature & Immersion Service

All sharp edges shall be ground to produce a radius and all imperfections such as skip welds, delaminations, scabs, slivers and slag shall be corrected prior to abrasive blasting. Skip welds shall be welded solid.

Degrease surface prior to sandblasting. Organic solvents, alkaline solutions, steam, hot water with detergents or other systems that will completely remove dirt, oil, grease, etc. may be used. Prebaking of used tanks is required. Additional decontamination may also be necessary.

The surface shall be blasted to a SSPC SP-5/NACE NO.1 white metal blast grade using a Venturi blast nozzle at 80 to 100 psi/5.5 to 7 bars. Reference Joint Surface Preparation Std. SSPC SP-5/NACE 1, White Metal Blast Cleaning. A blast profile depth or "tooth" in the metal shall correspond to approximately 20 to 25% of the total film thickness of the coating system.

The blast media used shall be a natural abrasive, steel grit or slag grit (similar or equal to BLACK BEAUTY®). These abrasives shall be sharp with a hard-cutting surface, properly graded, dry and of the best quality. The blast media shall be of proper size to obtain the specified blast profile depth and shall be free of all contaminants.

Remove all traces of grit and dust with a vacuum cleaner or by brushing. Care must be taken to avoid contaminating the surface with fingerprints or from detrimental material on the workers' clothes.

The surface temperature shall be maintained at a minimum of 5°F/3°C above the dew point to prevent oxidation of the surface. The coating shall be applied within the same day that the surface has been prepared.

### Aluminum

Surface shall be clean and grease-free with a blast produced anchor pattern or "tooth" as described earlier under STEEL. In addition, the blasted surface shall be given a chemical treatment such as:

ALODINE 1200S available from Henkel Surface Tech

IRIDITE 14-2 produced by MacDermid Incorporated

OAKITE CRYSCOAT 747LTS and OAKITE CRYSCOAT

ULTRASEAL produced by Oakite Products

For immersion, blasting with sharp grit followed by the chemical surface treatment is required.

**Note:** On metallic surfaces prepared only by chemical etching, the total coating film thickness applied should be restricted to only half the film normally applied to blasted surfaces. This reduced film thickness should be considered during selection of the coating for the service and the type of surface preparation performed.

## APPLICATION

### Spray

All spray equipment shall be thoroughly cleaned and the hose, in particular, shall be free of old paint film and other contaminants.

GUN	FLUID	AIR
DeVilbiss JGA-510	E	797
Binks #2001	66-SS	63-PB
Graco P800	04	02

Use standard production-type spray guns:

August 2007 replaces August 2003

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When airless spray equipment is used, the recommended liquid pressure is 1500 to 1800 psi/103 to 124 bars with a tip size from .013" to .019".

Air supply shall be uncontaminated. Adjust air pressure to approximately 50 lbs./3.4 bars at the gun and provide 10 to 15 lbs./7 to 1 bar pot pressure. Adjust spray gun by first opening liquid valve and then adjusting air valve to give approximately an 8-12 in/20-30 cm fan holding perpendicular to the surface at a distance of 12 in/30 cm.

Apply a "mist" bonding pass.

Allow to flash off for several minutes but not long enough to allow film to completely dry. Apply 3 to 4 crisscross multi-passes, maintaining a wet appearing film (approximately 4-6 mils/100-150 microns). This will dry to approximately 1-1.5 mils/25-38 microns DFT. Allow to flash off for several minutes but not long enough to allow film to completely dry. Apply 3 to 4 crisscross multi-passes, maintaining a wet appearing film (approximately 4-6 mils/100-150 microns). This will dry to approximately 1-1.5 mils/25-38 microns DFT.

Air dry with ventilation a minimum of 60 minutes prior to introducing heat.

After the air-dry time has elapsed, the substrate temperature should be increased at a time/temperature rate not to exceed 30°F/17°C every 30 minutes until the intermediate baking temperature has been reached. **Hold at 180°F-200°F for 20-30 minutes.**

After the substrate has cooled down to good application temperatures, prepare lining for succeeding coats.

Repeat for each separate coat and intermediate bake. 3 to 4 coats are recommended to attain 5-7 mils/125-175 microns DFT.

After final intermediate bake, check coating for DFT and holidays. Repair as needed.

Final bake at 375-400°F/191-204°C (400°F/204°C for sulfuric acid service) for 90 minutes or until proper color has been attained.

### SAFETY

#### READ THIS NOTICE

#### SAFETY AND MISCELLANEOUS EQUIPMENT

For tank lining work or enclosed spaces, it is recommended that the operator provide himself with clean coveralls and rubber soled shoes and observe good personal hygiene. Certain personnel may be sensitive to various types of resins which may cause dermatitis.

**THE SOLVENT IN THIS COATING IS FLAMMABLE AND CARE AS DEMANDED BY GOOD PRACTICE, OSHA, STATE AND LOCAL SAFETY CODES, ETC. MUST BE FOLLOWED CLOSELY.** Keep away from heat, sparks and open flame and use necessary safety equipment, such as, air mask, explosion-proof electrical equipment, non-sparking tools and ladders, etc. Avoid contact with skin and breathing of vapor or spray mist. When working in tanks, rooms and other enclosed spaces, adequate ventilation must be provided. Refer to Plasite Bulletin PA-3. Keep out of the reach of children.

**CAUTION - Read and follow all caution statements on this product data sheet, material safety data sheet and container label for this product.**



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